

Ship Dec 6 (30)

Dart Aerospace Ltd.

32

Date: Tuesday, 6/19/2007 4:40:43 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 UTILITY BASKET
Job Number : 33017	
Estimate Number : 10920	
P.O. Number : <u>N/A</u>	Part Number : D407663011
This Issue : 6/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2955 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 31999	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 8/5/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 1 Um: Each
Comment : Est Rev: F 05.10.19 Added D2728-3 & AN960JD416L KJ/JL M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 07/07/30

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D407-663-011CHG002

07/12/13

2.0	33017A	407 BASKET BASE ASSEMBLY
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Comment: Sub-Component 407 BASKET BASE ASSEMBLY

D2948-041 B 33017A

ml 07/12/13

3.0	33017B	407 BASKET LID
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Comment: Sub-Component 407 BASKET LID

D2952-041 B 33017B

ml 07/12/13

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass

33467

KS 07/12/11

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 4:40:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

33939

AS 07/12/11

(X)

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

B34590

AS 07/12/11

(X)

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

B34788

AS 07/12/11

(X)

9.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label

B22553

AS 07/12/11

(X)

10.0

D2851145

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 d2851-145 Placard

~~B30017~~ B30019

AS 07/12/11

(X)

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper

21139

AS 07/12/11

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2961

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D22961

Label

B 12077

D2961

AS 07/12/11

(X1)

13.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-20A

Bolt

M 15432

AS 07/12/11

(X1)

14.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-14A

Bolt

M 105053

AS 07/12/11

(X1)

15.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-22A

Bolt

M 62059

AS 07/12/11

(X1)

16.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-17A

Bolt

M 64885

AS 07/12/11

(X1)

17.0

AN521A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-21A

Bolt

M 10463

AS 07/12/11

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer

M105906

AS 07/12/11

(X)

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

M105728

AS 07/12/11

(X)

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M104156

AS 07/12/11

(X)

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer

M105057

AS 07/12/11

(X)

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M105442

AS 07/12/11

(X)

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

M18071

AS 07/12/11

(X)

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 MS20600AD4W3 Rivet

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M105558

JS 2/12/11 (X1)

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M105054

JS 2/12/11 (X1)

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M105430

JS 2/12/11 (X1)

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024.

mulo 7/12/13

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 7/12/13 (X1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2852

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D2852 Label B30108

AS 07/12/11 (X1)

31.0

D2984

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D2984 Label B12605

AS 07/12/11 (X1)

32.0

D407301011

Center Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D407-301-011 Center Bracket Kit 33400

AS 07/12/11 (X1)

33.0

D407302011

Outboard Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D407-302-011 Outboard Bracket Kit 33401

AS 07/12/11 (X1)

34.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 AN3-11A Bolt M14820

AS 07/12/11 (X1)

35.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 AN960JD10 Washer M105792

AS 07/12/11 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 33017

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

6 MS21042L3

Nut (or -3)

M105558

M105558

AS 07/12/11

(XL)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



ONLY inspected kit.



Comment: INSPECT 100% KITS FOR COMPLETENESS

(

7/12/11

(XL)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-663-011

Location:

PPP Rev:

6/7/13

(1)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007/12/13

Job Completion



u 8/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY	SCALE NTS
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2 A	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2 A	AN960JD8	WASHER
4	AN970-4	WASHER
2 A	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF

#00.09.08
RF

#00.09.08
RF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33017

RELEASED
00.07.18 #

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D2952-041 BASKET
LID ASSEMBLY

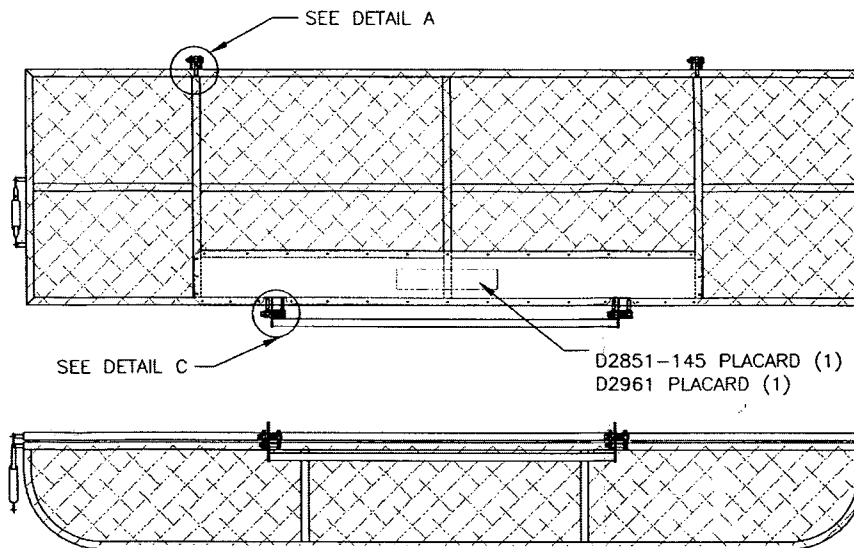
AN4-22A BOLT (1)
AN960JD416 WASHER (1)
AN970-4 WASHER (2)
MS21042L4 NUT (1)

D2948-041 BASKET
BASE ASSEMBLY

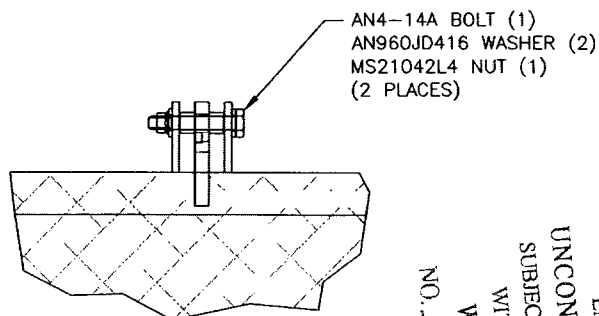
PROP ARM DETAIL

SEE DETAIL B

D2332-041 LID
PROP ASSEMBLY



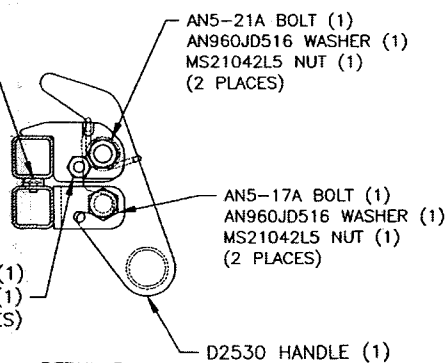
D2955-041 BASKET ASSEMBLY



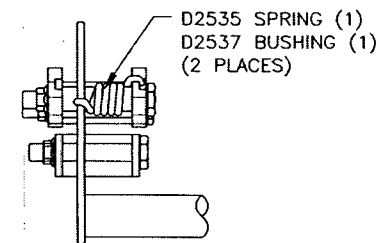
DETAIL A
HINGE DETAIL

D2931 BUMPER (1)
MS20600AD4W3 (1)
AN960JD8 WASHER (1)
(2 PLACES)

AN3-20A BOLT (1)
MS21042L3 NUT (1)
(2 PLACES)



DETAIL B
LATCH DETAIL



DETAIL C
SPRING DETAIL

RELEASED
00.07.18

NO. 17
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN RF	DRAWN BY RF	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED df	APPROVED df	DRAWING NO. D2955	REV. B SHEET 2 OF 2
DATE 00.07.17	TITLE BASKET ASSEMBLY	SCALE NTS	

32

Date: Tuesday, 6/19/2007 4:40:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 BASKET BASE ASSEMBLY
Job Number : 33017A	
Estimate Number : 10912	
P.O. Number :	Part Number : D2948041
This Issue : 6/19/2007 S.O. No. :	Drawing Number : D2948 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 31999A	Material :
Written By :	Due Date : 8/5/2007 Qty: 1 Um: Each
Checked & Approved By : <u>ADD. 06.20</u>	
Comment : Est Rev:E 04.08.09 Revised Step 1 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W049	304 SQ Tube.75x.75x.049W
-----	----------------	--------------------------



Comment: Qty.: 48.9993 f(s)/Unit Total : 48.9993 f(s)

Material: 304/316 SS tube 0.049" wall

(M304TS0.750W.049)

Batch: M16444, 19161, M15357, 103069

m103069 FL 07/12/05
m103240

EL 7-12-4

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948

7-12-4

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019

EL 7-12-4

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PD 07-12-07

5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2327-3 Spacer

034589

PD 07-12-07

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 33017A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket

B34507

PD 07-12-07

7.0

D2954

Mounting Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

Batch

4 D2954 Mounting Plate

D2525

PD 07-12-07

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description

Batch

32sf M304EX0.75-16F SS Expanded Metal

M106443

PD 07-12-07

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and Deburr/Identify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948

Identify properly as D2948-1/-3/-7/-9

3-Remove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Deburr as required.

A/R SS Rod

Batch

M105524

PD 07-12-11

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

2/07/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/12/13
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 33017A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/13

12.0

POWDER COATING

POWDER COATING



M 105914



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 07-12-13

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07/12/13

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

M 07/12/13

15.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/12/13

Job Completion



07/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

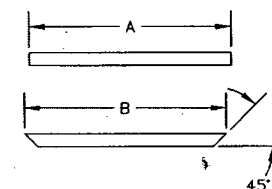
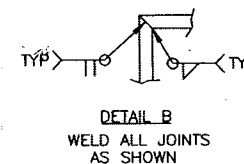
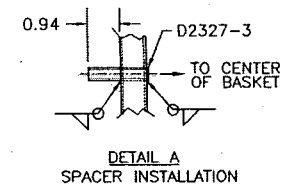
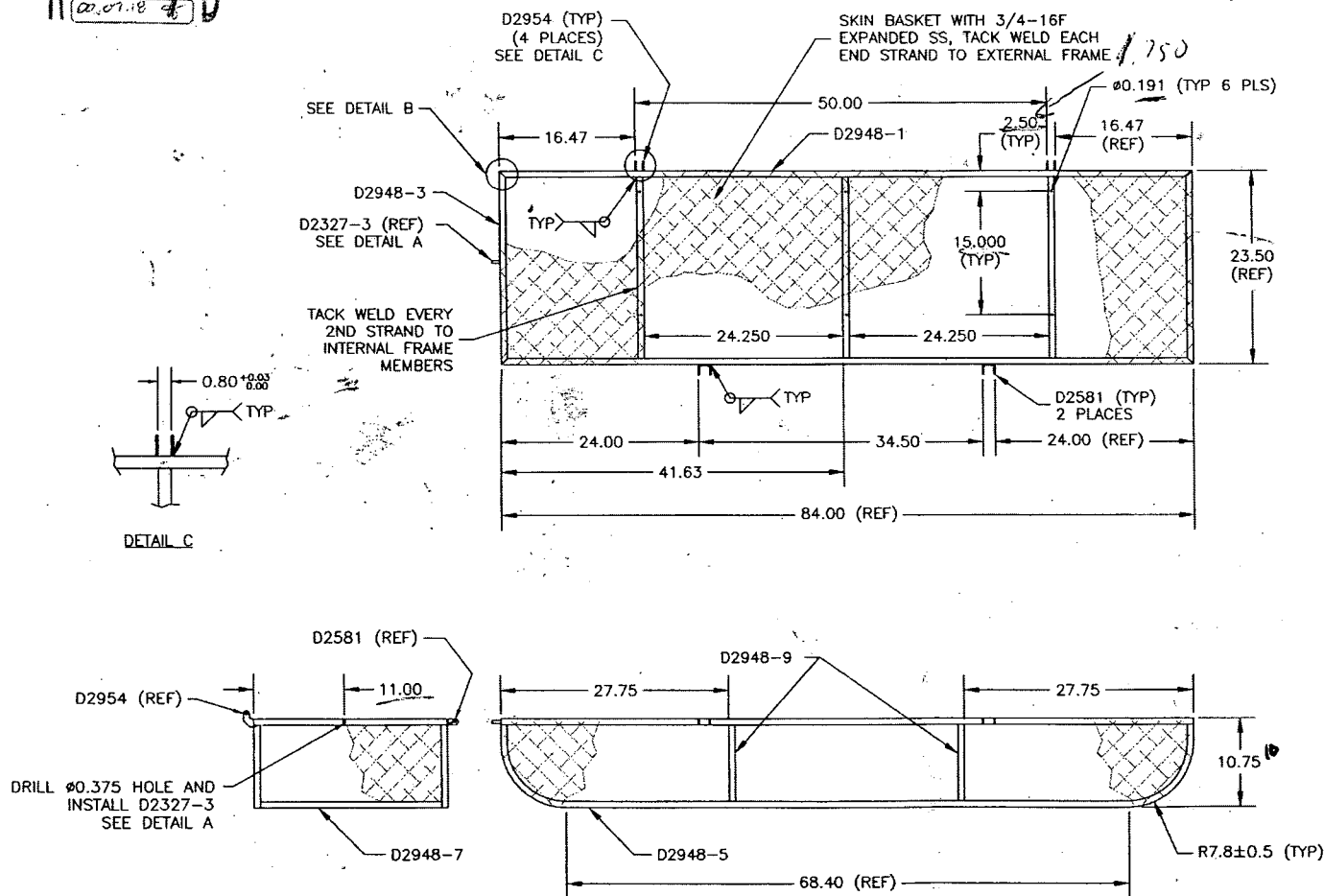
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
00.07.18



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
 MESH MATERIAL: 3/4-16F EXPANDED SS
 FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 WELD PER DART QSI 004
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 33017 A
 WORK ORDER
 WITHOUT NOTICE
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B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY RF
CHECKED	RF	APPROVED RF
DATE	00.07.17	TITLE BASKET BASE ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

DART DART AEROSPACE LTD.
 HAMBURG, ONTARIO, CANADA

Date: Tuesday, 6/19/2007 4:41:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 BASKET LID
Job Number	: 33017B		
Estimate Number	: 10917		
P.O. Number	:	Part Number	: D2952041
This Issue	: 6/19/2007 S.O. No. :	Drawing Number	: D2952 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 31999B	Material	:
Written By	:	Due Date	: 8/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.06.20</u>		
Comment	: Est Rev: C 03.11.26 Reformat KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6TS0750W062	6061-T6 SQ Tube .75x.062W
-----	-------------------	---------------------------



Comment: Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s)
Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall
(M6061T6TS0.750W.062)
Batch: M103069

PD 07-11-29

2.0	M5052H32S080	5052-H32 .080 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s)
Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080"
(M5052H32S.080) or 6061T6S080 (M6061T6S080)
Batch: M104392
Identify as D2952-11

PD 07-12-04

3.0	D2953077	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2953-077 Spacer B22095 → 1

PD 07-12-04

4.0	D2953175	Spacer
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2953-175 Spacer B22096

PD 07-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 4:41:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 33017B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2957

Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

6 D2957

Mounting Plate

B29869 → 4

B21198 → 2

PD 07-12-04

6.0

M1100H14ES34X051F

Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total : 15.7500 sf(s)

Pick:

Qty Part Number

Description

Batch

15sf M1100H14ES-3/4x.051F

Mesh

M103088

PD 07-12-05

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD

Batch:

M106330

PD 07-12-06 1

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/12/12 ①

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/12/12 ②

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: LD Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 4:41:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 33017B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2983

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label Plate 032023

FC 07/12/12

12.0

MS20600AD4W2

Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
Rivet 41747

FC 07/12/13

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 07/12/12

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

FC 07/12/12

15.0

POWDER COATING

POWDER COATING



M10S914



(IX)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M. 07/12/13

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/12/13

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

m 07/12/13

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/12/13

Job Completion



n 07/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

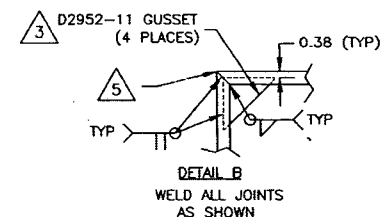
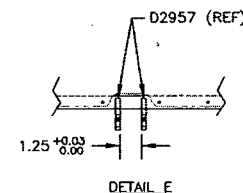
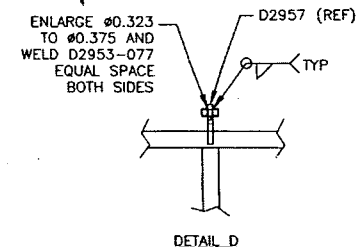
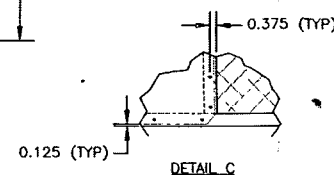
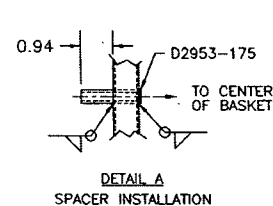
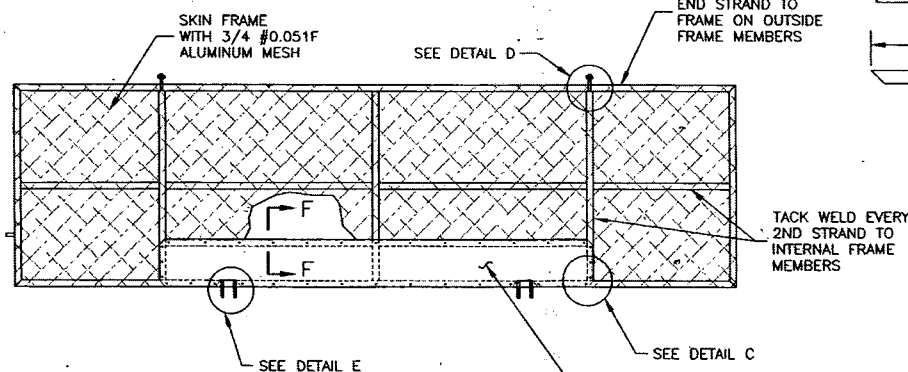
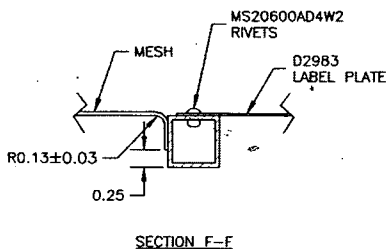
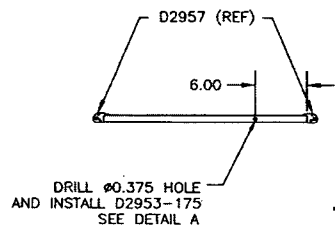
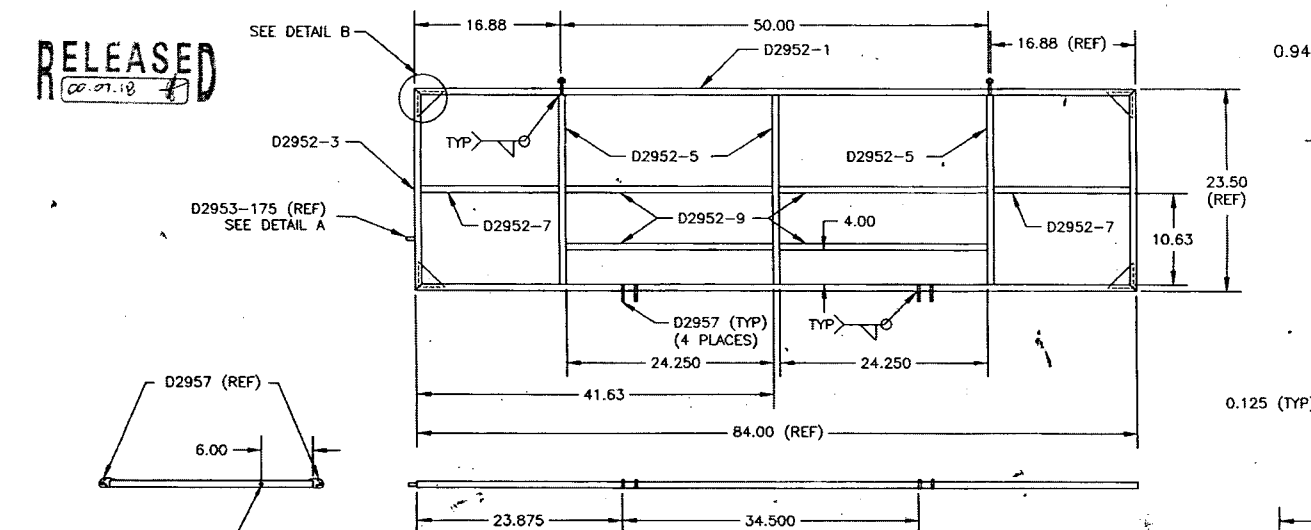
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
00-07-18



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
1	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

- NOTES:
- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING (Qa-A-200/8 or Qa-A-225/2)
 - 2) MESH MATERIAL: 5005-H34 OR 3003-H14 OR 1100-H14/H18 3/4 $\phi 0.051F$.
 - 3) GUSSET MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32/H34 (QQ-A-250/8) (3.00 x 3.00) 0.080 THICK
 - 4) WELD PER DART QSI 004
 - 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE WELDING CORNERS (TYP. 4 PLACES)
 - 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE, GRIND CORNER WELDS (4 PLS) BOTTOM SIDE FOR GUSSET
 - 7) TRANSFER D2983 LABEL PLATE HOLES USING $\phi 0.128$ DRILL INSTALL D2983 ONTO FRAME USING MS20600AD4W2 RIVETS (TYP. 34 PLACES)
 - 8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 - 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 33017B

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B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN	RF	DRAWN BY RF
CHECKED	#	APPROVED
DATE	00.07.06	TITLE BASKET LID ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

DART DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

